

6061 Ø.625 .065W

Work Order ID 130731

130731

Tuesday, March 24, 2015 10:25:47 AM

Item ID: D2743

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crossbolt Spacer

Start Date: 3/24/2015 Start Qty: 160.00

160

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 160.00

160

Customer:

Reference:

Approvals:

Process Plan:

MLJ

Date:

1503-24

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2743

Rev B

100

0.01

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.05

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA202 & DWG D2743

FOLIO REV: AA

DWG REV: 3

2-DEBURR AS REQUIRED

170

36

15-04-07

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.03

Quality Control

170

36

15-04-07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Process Plan:

Date:

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Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.05

Quality Control

SL15-47

130

0.00

130

Skidtubes

Memo

0.00

Skidtubes

1- Clean crossbolt spacer with ultra bright aluminum cleaner

170 ~~0~~ BE15-04-08

160

Identify as per dwg & Stock Location: LG

0.00

160

Packaging

Memo

0.03

Packaging

STOCK IN SKIDTUBE CELL

170 ~~0~~ BA15-04-08

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Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.27

Quality Control

MLJ 1504-08

15.4-8

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Picklist Print

Tuesday, March 24, 2015 10:25:54 AM

Page 1

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130731

Parent Item: D2743

D2743

Parent Item Name: Crossbolt Spacer

Start Date: 3/24/2015

Required Date: 3/24/2015

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP E05.04.13Reformat; removed tumble and deburr stepKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.625W.065		Purchased	No			100	f	36.0000	0.2667	45			

M6061T6T0 625W 065

**

6061-T6 RD Tube .625 x.065W

Location

Loc Qty

Loc Code

MAT014

36

m131505

36

131932

36

12

48

36

15.04.07

DQA: _____ Date: _____



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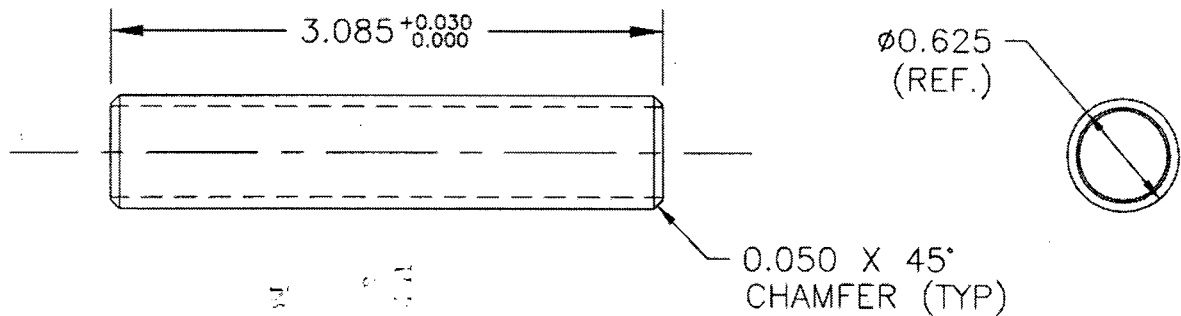
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DESIGN HA	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED HA	APPROVED <i>KE</i>	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	98.12.08	3.085 WAS 3.060	

RELEASED
98.12.16 DS



1805-24
130731 MLC
11/11/98

MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED